

Date: Wednesday, 1/23/2008 12:05:51 PM  
 User: Kim Johnston

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: MIRROR BRACKET RH
Job Number	: 36938		
Estimate Number	: 10147		
P.O. Number	:	Part Number	: D20132
This Issue	: 1/23/2008 S.O. No. :	Drawing Number	: D2013 REV C
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: / / Type : SMALL /MED FAB	Drawing Revision	: C
Previous Run	: 36467A02	Material	:
Written By	:	Due Date	: 1/30/2008 Qty: 5 Um: Each
Checked & Approved By	: <u>1080123</u>		
Comment	: Est Rev:A New Issue 05-11-01 JLM		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M304TR0750W049	304 RD Tube .750 x .049W
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Comment: Qty.: 2.0447 f(s)/Unit Total : 10.2233 f(s)  
 Material: 3/4 O.D. x .049" wall, 304/316 SS Seamless Tubing  
 (M304TR0.750W.049)  
 Batch: M 107098

SB 08/02/12

⑤

2.0	BRAKE NC	NC BRAKE
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Comment: NC BRAKE

1-Punch as per template D2013-T1 and Dwg D2013

2-Flatten ends of D2013-2 tube as per Dwg D2013 using DT8545

3-Bend (1) tube as per Dwg D2013 using Jig DT8201 identify as D2013-2.

4-Deburr as required

SB 08/02/12  
08/02/14 ⑤

FF 08-02-19

⑤

⑤

08/02/14 ⑤

3.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP

08-02-20 ⑤

4.0	QC21	FINAL INSPECTION/W/O RELEASE
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Comment: FINAL INSPECTION/W/O RELEASE

08/02/20 ⑤

Job Completion



stay

08/02/20 ⑤

08/02/20 ⑤

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: 2 Date: 28/01/22

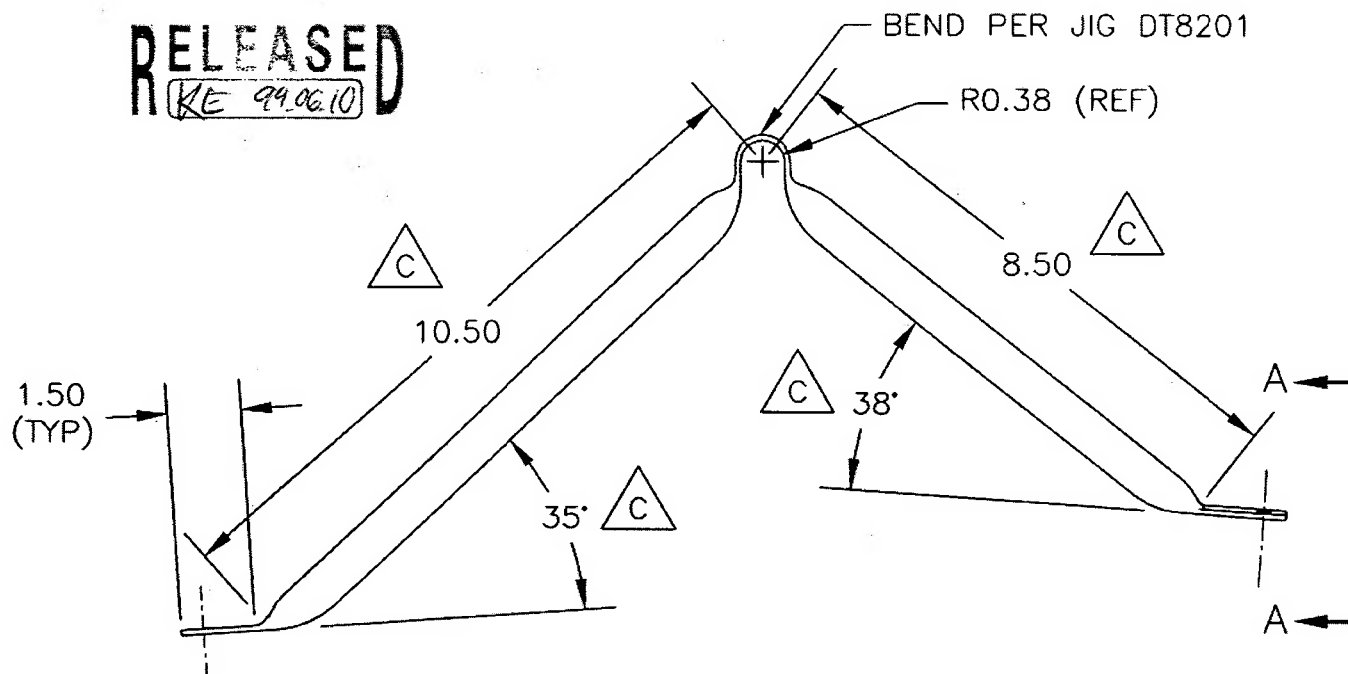
QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

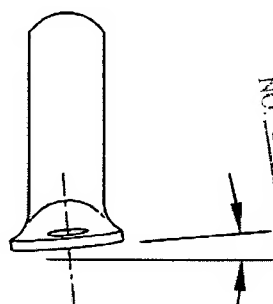
NOTE: Date & initial all entries

RELEASED  
KE 99.06.10

**DART**



D2013-1 LH SHOWN  
D2013-2 RH OPPOSITE  
(FOR 205 MIRROR)



VIEW A-A

DRILL  $\varnothing 0.257$  (TYP)

0.400 (TYP)

NO. 36938  
WORK ORDER  
SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE

CUT LENGTH: 23.25 INCHES

MATERIAL: AISI 304/316 SS SEAMLESS TUBE,  
0.750 OD x 0.049 WALL

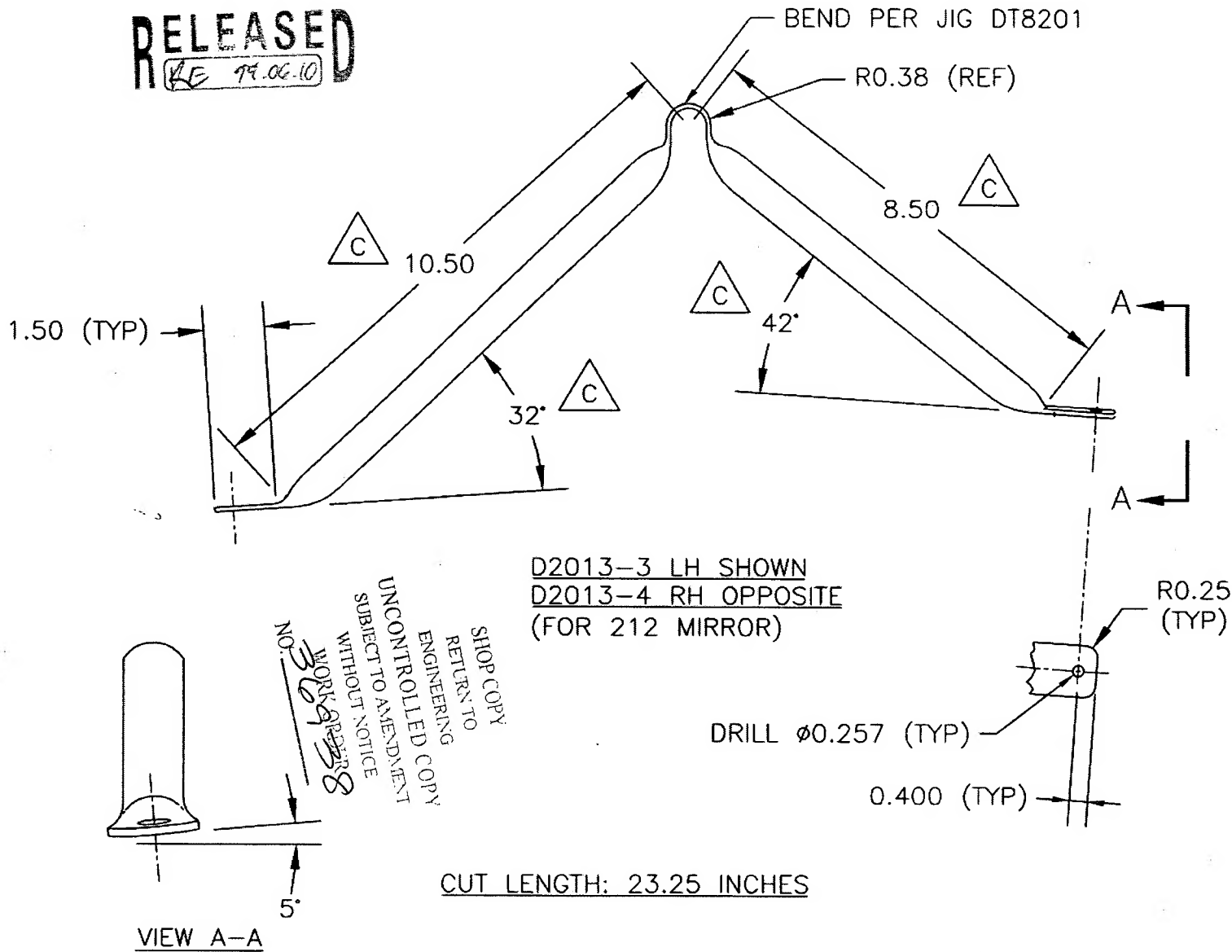
DESIGN	DRAWN BY	DART AEROSPACE LTD HAMKESBURY, ONTARIO, CANADA
JB	RF	
CHECKED	APPROVED	DRAWING NO.
KE	RF	D2013
DATE	TITLE	REV. C
99.06.07	MIRROR BRACKET	SHEET 1 OF 3
A	90.10.22	NEW ISSUE
B	94.06.15	REDRAWN
C	99.06.07	REDRAWN, CHANGE OF DIMENSIONS
		SCALE NFS

RELEASED  
KE 99.06.10

**DART**



DESIGN	DRAWN BY	DART AEROSPACE LTD HAMKESBURY, ONTARIO, CANADA	REV. C
JB	RF		
CHECKED	APPROVED	DRAWING NO.	SHEET 2 OF 3
KE	[Signature]	D2013	
DATE	TITLE	SCALE	NTS
99.06.07	MIRROR BRACKET		

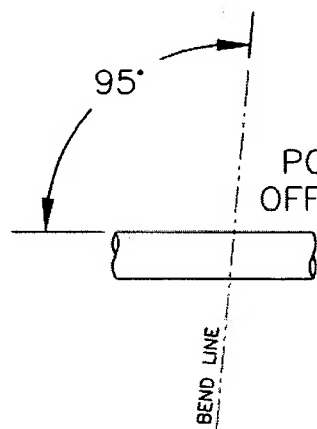
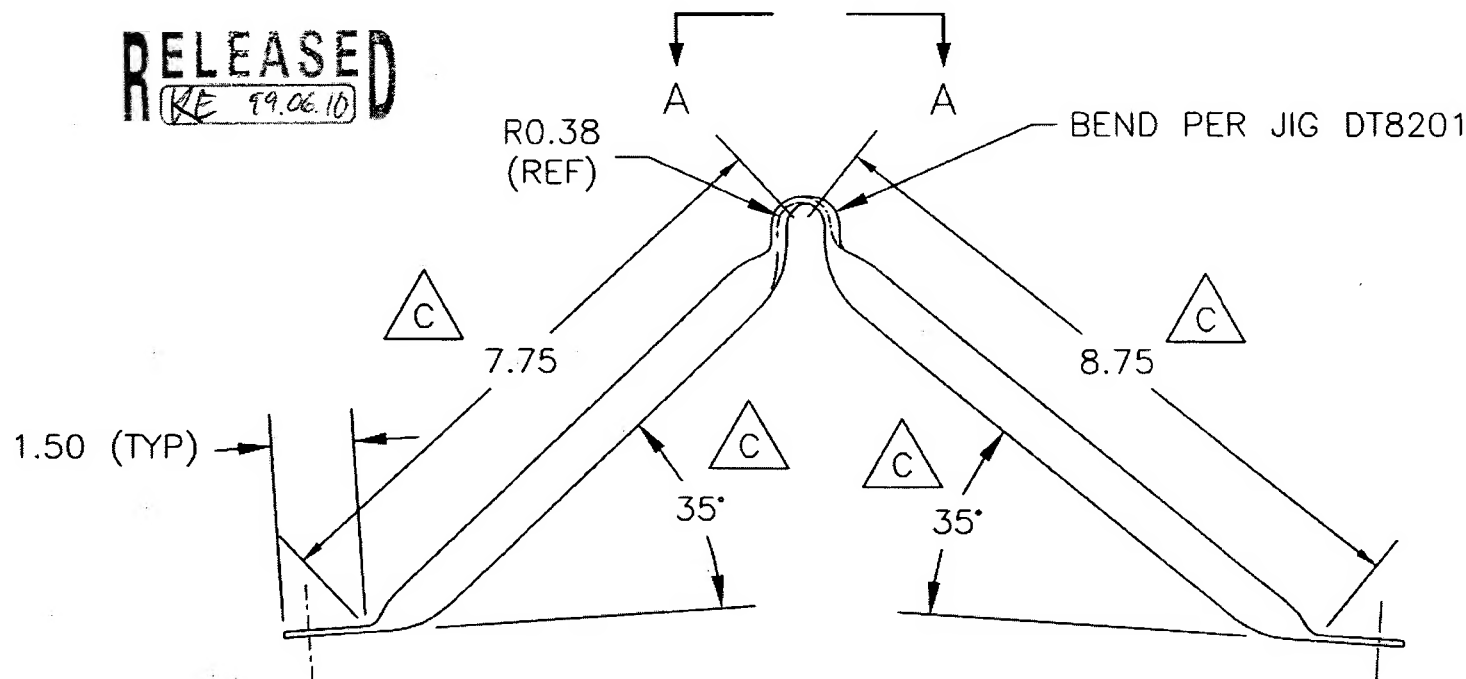


RELEASED  
KE 99.06.10

**DART**

REPRODUCED

DESIGN	JB	DRAWN BY	KE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	KE	APPROVED	KE	DRAWING NO. D2013
DATE	99.06.07	TITLE	MIRROR BRACKET	REV. C
				SHEET 3 OF 3
				SCALE
				NTS



POSITION TUBE  
OFFSET 5  
SUBJECT TO AMENDMENT  
NO. 36938  
WORK ORDER  
NO. 36938  
SHOP COPY  
RETURN TO  
ENGINEERING  
CONTROLLED COPY  
IN JIG

D2013-5 LH SHOWN  
D2013-6 RH OPPOSITE  
(FOR 204 MIRROR)

DRILL  $\phi 0.257$  (TYP)  
R0.25 (TYP)  
0.400 (TYP)

CUT LENGTH: 20.75 INCHES

MATERIAL: AISI 304/316 SS SEAMLESS TUBE,  
0.750 O.D. x 0.049 WALL